

Date: Wednesday, 9/10/2008 9:13:16 AM
 User: David Duval

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARMREST KIT, LH
Job Number	: 41926		
Estimate Number	: 13564		
P.O. Number	:	Part Number	: D412761049
This Issue	: 9/10/2008 S.O. No. :	Drawing Number	: PRELIM 08.09.10 Rev.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: PRELIM
Previous Run	:	Material	:
Written By	:	Due Date	: 9/17/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-09-10 new issue DD verified by:JLM		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-761-049 CHG001

N/A

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3694041	MOUNTING PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

MOUNTING PLATE
batch: 538771

AS 08/09/11 08.09.11 (12)

4.0	D3695041	Slider Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Slider Assembly
batch: 538695

AS 08/09/10 (7)

5.0	D3780041	Armrest Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Armrest Assembly
batch: 541919

AS 08/09/10 (8)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST KIT, LH

Job Number: 41926

Part Number: D412761049

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN36A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

batch: M167959

SS 08/09/10 (X)

7.0	AN626	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: M1681p

SS 08/09/10 (X)

8.0	AN3106	Castellated Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Castellated Nut

batch: M165279

SS 08/09/10 (X)

9.0	AN960JD10	Washer
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

batch: M169059

SS 08/09/10 (X)

10.0	AN960JD616L	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M162630

SS 08/09/10 (X)

11.0	NAS1515H6L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: M18918

SS 08/09/10 (X)

12.0	MS24665285	Cotter Pins
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cotter Pins

batch: M9003

SS 08/09/10 (X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D412761049

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 MS21071L3 ANCHOR NUT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
ANCHOR NUT
batch: M102589

SS 08/09/10 (x1)

14.0 MS21075L3 Nutplate



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)
Nutplate
batch: M109008

SS 08/09/10 (x1)

15.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



**ENGINEERING
APPROVAL**

08.09.11 Comment: INSPECT 100% KITS FOR COMPLETENESS

08.09.11 (x1)

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D412-761-049
Location:
PPP Rev:
DRAFT

send to E226*

SS 08/09/10 (x1)

17.0 QC24 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



* FOR FLIGHT TEST ONLY 08.09.11

00224A

08.10.23

POSITIVE
RECALL

PRELIMINARY ISSUE

POSITIVE RECALL

EFFECTIVE 08.09.11 AUTH u

RELEASED 09.02.12 DATE I

6.0 D412-761-041 BREAKDOWN

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
1	X				D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
		1			D3676-1	LARGE BUBBLE WINDOW
		1			D3678-1	PLACARD
		1			D3700-1	INBOARD WINDOW DOUBLER
		1			D3700-3	OUTBOARD WINDOW DOUBLER
		1			D3701-1	FLOOR DOUBLER
		1			D3702-1	FORWARD DOUBLER
		1			D3703-1	AFT DOUBLER
		1			D3703-3	AFT CORNER DOUBLER
		1			D3703-5	AFT CAP
		1			D3704-1	ESCUTCHEON
		1			D3708-1	ANGLE
		1			D3708-3	ANGLE
		1			D3709-1	ANGLE
		1			D3709-3	ANGLE
		1			D3802-1-135	SEAL
		1			D3818-1	WINDOW CUTOUT TEMPLATE
		26			AN3-7A	BOLT
		52			AN960JD10	WASHER
		26			MS21042L3	NUT
		1			MS24694-C5	SCREW (OR MS24694-S5)
		1			MS24694-C13	SCREW (OR MS24694-S13)
			1		D3705-041	INSTRUMENT PANEL ASSEMBLY
			1		D3705-043	* INSTRUMENT PANEL WELDMENT
			1		D3335-1	* SPRING
			1		D3705-5	* ACCESS PANEL
			1		D3706-5	* PIN
			2		D3707-3	* MOUNTING LUG

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

41926

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(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			4		AN526C1032R6	* SCREW
			1		AN960JD516	* WASHER
			1		MS171498	* SPRING SLOTTED PIN
			4		MS24693-C272	* SCREW (OR MS24693-S272)
			1		MS35489-156	* GROMMET
			2		D3707-1	MOUNTING LUG
			1		D3790-1	INDEXING BLOCK
			2		AN960JD10L	WASHER
			6		MS21075L3	NUTPLATE (OR MS21073-3)
			4		MS24693-C272	SCREW (OR MS24693-S272)
			1		MS27039-1-17	SCREW
			1		MS27039-1-27	SCREW
				1	D3694-041	MOUNTING PLATE ASSEMBLY
				1	D3694-1	* MOUNTING PLATE
				1	D3694-3	* PROTECTIVE PLATE
				1	AN526C1032R8	* SCREW
				1	AN960JD10	* WASHER
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				1	D3695-041	SLIDER ASSEMBLY
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	D3780-041	ARMREST ASSEMBLY
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				10	AN3-6A	BOLT
				1	AN6-26	BOLT
				1	AN310-6	CASTELLATED NUT
				10	AN960JD10	WASHER
				1	AN960JD616L	WASHER
				2	NAS1515H6L	WASHER
				1	MS24665-285	COTTER PIN
				3	MS21071L3	ANCHORNUT
				7	MS21075L3	NUTPLATE

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